

Date: Monday, 1/16/2006 4:10:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SCUFF PLATE
Job Number : 25499	
Estimate Number : 11946	
P.O. Number : N/A	Part Number : D206555002
This Issue : 1/16/2006 S.O. No. : N/A	Drawing Number : D206-555 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : 8C
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 2/20/2006
Checked & Approved By : _____	Qty: 10 Um: Each
Comment : est rev C 99.06.29 returned to electro polish DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 298

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg

Possible supplier: Ind. Laser

Material release note is required.

2.0	D206555002F	scuff plate flat
-----	-------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit: Total: 10.0000 Each(s)
 scuff plate flat

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555
 using DT 8314-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:10:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 25499

Part Number: D206555002

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8315-2

FF 06.10.03
SB 06/03/09 (11)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 09. 26 (11)

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 2181
Electro polish

C 206/10/04 (11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

PC 4/19/16 (11)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Feb 10. 18

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

6-1

(P10)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST139

P 06/10/04 (11)

LB 06/10/08 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-18	11.	Tabs to be removed a step 6. Perm change					06-10-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:10:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 25499

Part Number: D206555002

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 02/18/20 (14)

Job Completion



Handwritten: 06/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

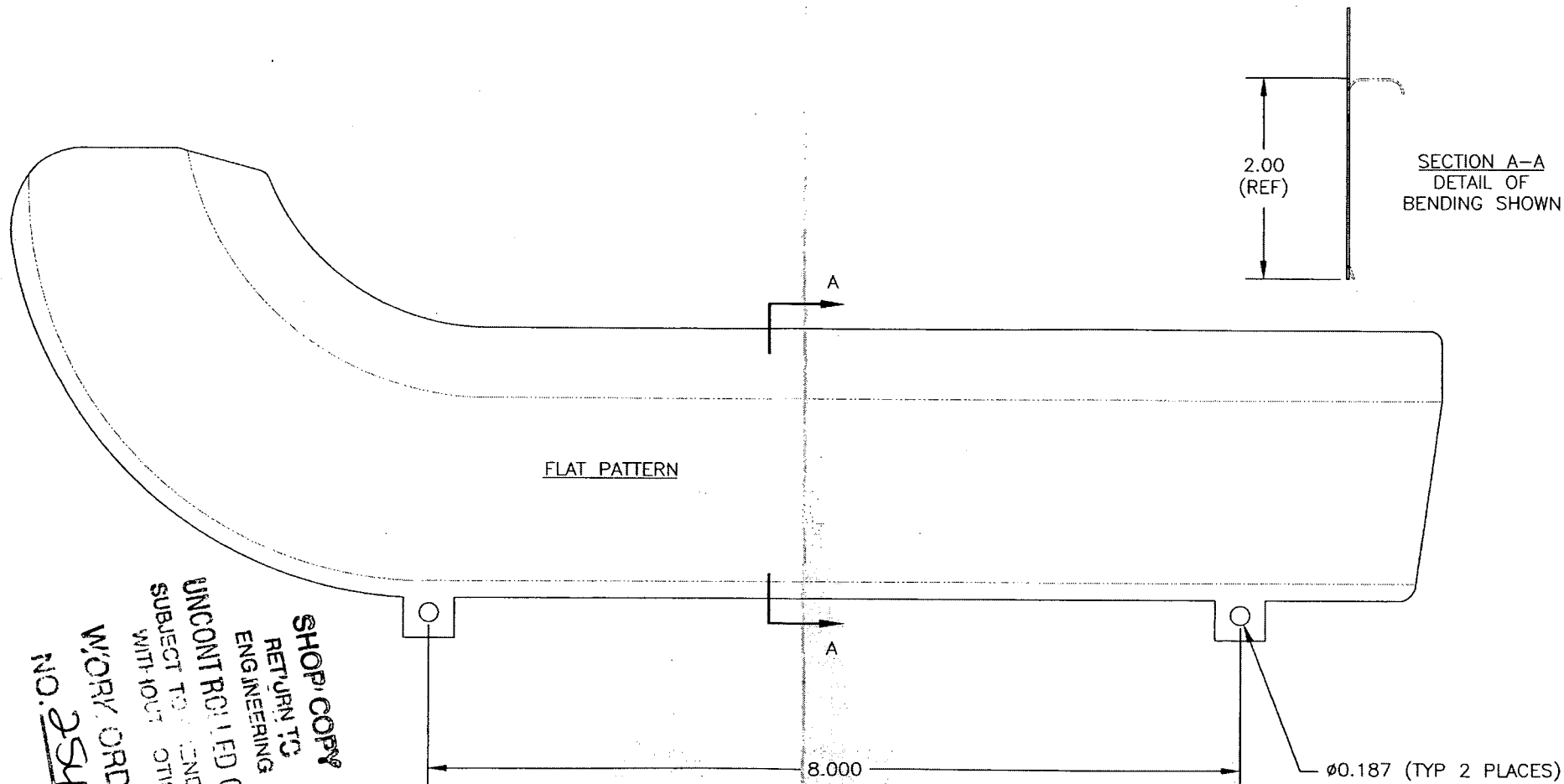


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D206-555	REV. B SHEET 1 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES SCALE NTS	
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	

RELEASED
99.01.11 KE

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 25499



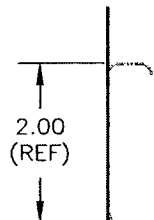
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WITH OUT OFFICE
WORK ORDER
NO. 25449

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T1
MATERIAL: AISI 304/316 0.020 THICK
FINISH: BRIGHT COLD ROLLED (2B)
NO SCRATCHES ON SURFACES
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.01.11 KE

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED JA	APPROVED [Signature]	DRAWING NO. D206-555	REV. B SHEET 2 OF 7
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION C-C
DETAIL OF
BENDING SHOWN

DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

16.000 (REF)

FLAT PATTERN

8.000

8.000

Ø0.187 (TYP 3 PLACES)

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

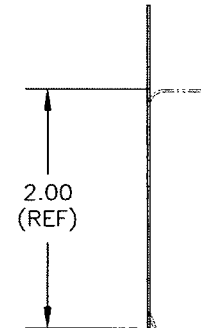
BEND PER M/F TEMPLATE D206-555-T3
MATERIAL: AISI 304/316 0.020 THICK
FINISH: BRIGHT COLD ROLLED (2B)
NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.01.11 KE



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	REV. B SHEET 3 OF 7 SCALE 2:3



SECTION D-D
DETAIL OF
BENDING SHOWN

FLAT PATTERN

8.000

Ø0.187 (TYP 2 PLACES)

D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T5
MATERIAL: AISI 304/316 0.020 THICK
FINISH: BRIGHT COLD ROLLED (2B)
NO SCRATCHES ON SURFACES

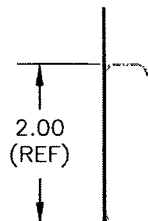
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.01.11 KE



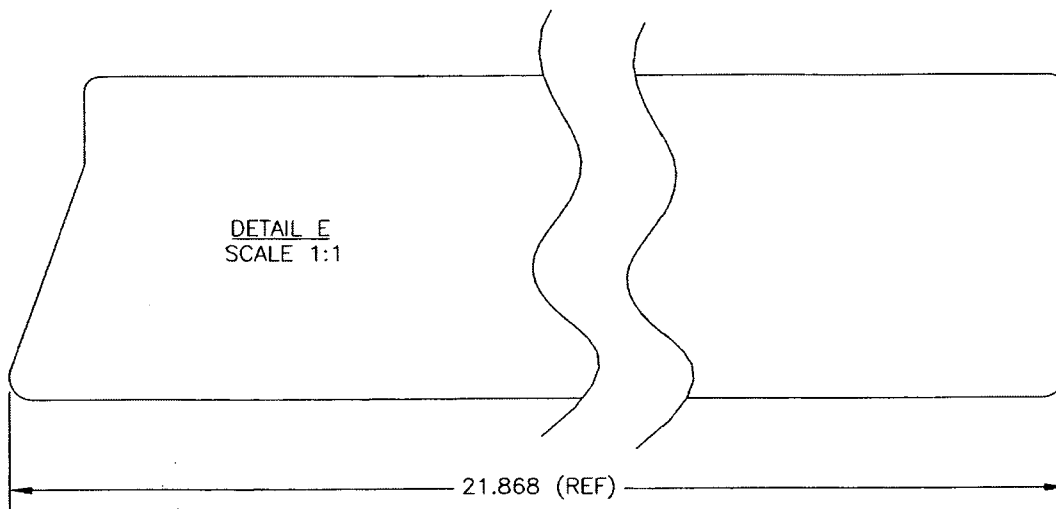
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D206-555	REV. B SHEET 4 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1

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NO. 25499
WORK ORDER
NO. 25499



SECTION F-F
DETAIL OF
BENDING SHOWN

DETAIL E
SCALE 1:1



REFER TO DETAIL E
FOR 1:1 SCALE

Handwritten: # 00.08.28
CP 00.08.28

FLAT PATTERN



D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

BEND PER M/F TEMPLATE D206-555-T7

MATERIAL: AISI 304/316 0.020 THICK

FINISH: BRIGHT COLD ROLLED (2B)

NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

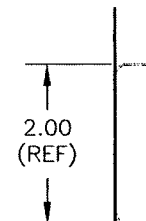
RELEASED
Handwritten: 99.01.11 KE



DESIGN <i>Handwritten:</i> [Signature]	DRAWN BY <i>Handwritten:</i> [Signature]	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED <i>Handwritten:</i> [Signature]	APPROVED <i>Handwritten:</i> [Signature]	DRAWING NO. D206-555
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	REV. B SHEET 5 OF 7 SCALE 2:3

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Handwritten:
NO. 254499
WORK ORDER
NO. NOTICE
ATTENTION
DETAILING
ENGINEERING
SHOP CORN



SECTION H-H
DETAIL OF
BENDING SHOWN

REFER TO DETAIL G
FOR 1:1 SCALE

DETAIL G
SCALE 1:1

16.000 (REF)

Handwritten: H #0.05-28
Q 0.08-28

FLAT PATTERN

8.000

Handwritten: H

8.000

Ø0.187 (TYP 3 PLACES)

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

BEND PER M/F TEMPLATE D206-555-T9

MATERIAL: AISI 304/316 0.020 THICK

FINISH: BRIGHT COLD ROLLED (2B)

NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

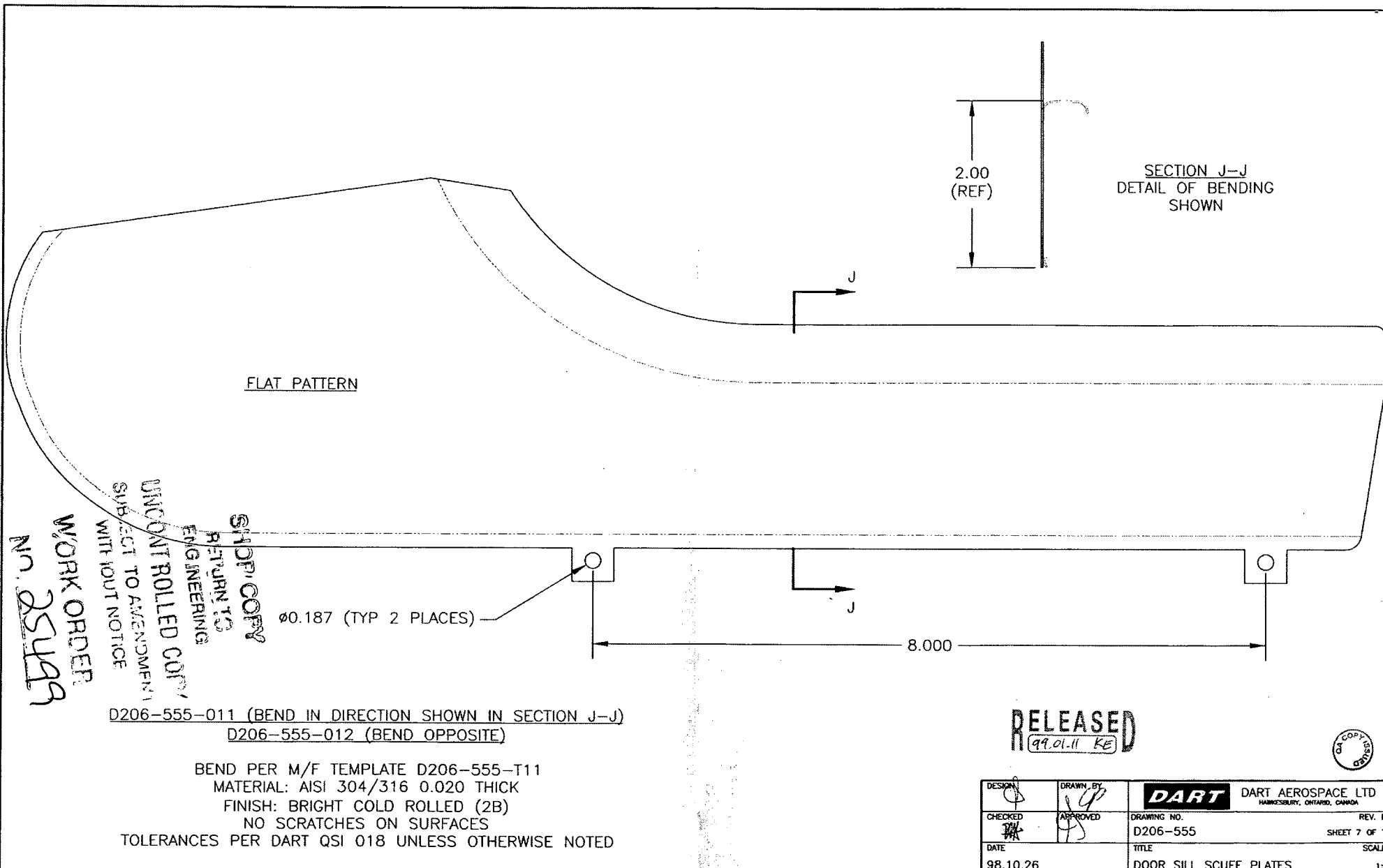
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3

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RELEASED
[Handwritten: 01.01.11 KE]



NO. 25499
WORK ORDER
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SECTION
OFFICE



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ENGINEERING
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SUBJECT TO AMENDMENT
WITH OUT NOTICE
WORK ORDER
NO. 25499

D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T11
MATERIAL: AISI 304/316 0.020 THICK
FINISH: BRIGHT COLD ROLLED (2B)
NO SCRATCHES ON SURFACES
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.01.11 KE

COPY

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D206-555	SHEET 7 OF 7
98.10.26		TITLE	SCALE
		DOOR SILL SCUFF PLATES	1:1



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 290000 02

Mail To:

WILKINSON STEEL AND METALS
ATTN: MILL CERTIFICATE SCANNER
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:

WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 11/22/2005

Page: 1

Steel: 304

Finish: 2B

Your Order: P51013PC004

NAS Order: AE 0329272 02

Corrosion: ASTM A262/02aE, 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04
Q8S766D-A X MG PRM, AMS5513H X MRR&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B40627	* 0679E9 A	.0240	48.0000	2,475 SHEET	120.00	2	65
B40628	* 0679E9 A	.0240	48.0000	2,485 SHEET	120.00	3	65

060405

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
79E9	.057	18.152	.369	1.666	.319	.046	8.205	.029	.001	.326

MECHANICAL PROPERTIES

Product ID #	Coil #	Id oi cr	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B40627	0679E9	F T	97.09	48.19	48.98	49.00	46.50
B40628	0679E9	F T	97.09	48.19	48.98	49.00	46.50

QC ENGINEER

ERIC HESS

11/22/2005

215MD007-1 T M INDUSTRIAL (P51013PC004.79E9)

Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: October 12, 2006

1270 Aberdeen St

Hawkesbury, Ontario


No. de certificat
Certification No.

K6A 1K7

tel.: (613) 632-9577

fax: (613) 632-1053

C108535

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
119118		NO. DE COM./P.O.# <u>2181</u>	ELECTROPOLISH PER ASTM B912 REV.02
	11	D206-555-002 ✓	
	11	D206-555-001	
	10	D206-555-007	
	10	D206-555-009	

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

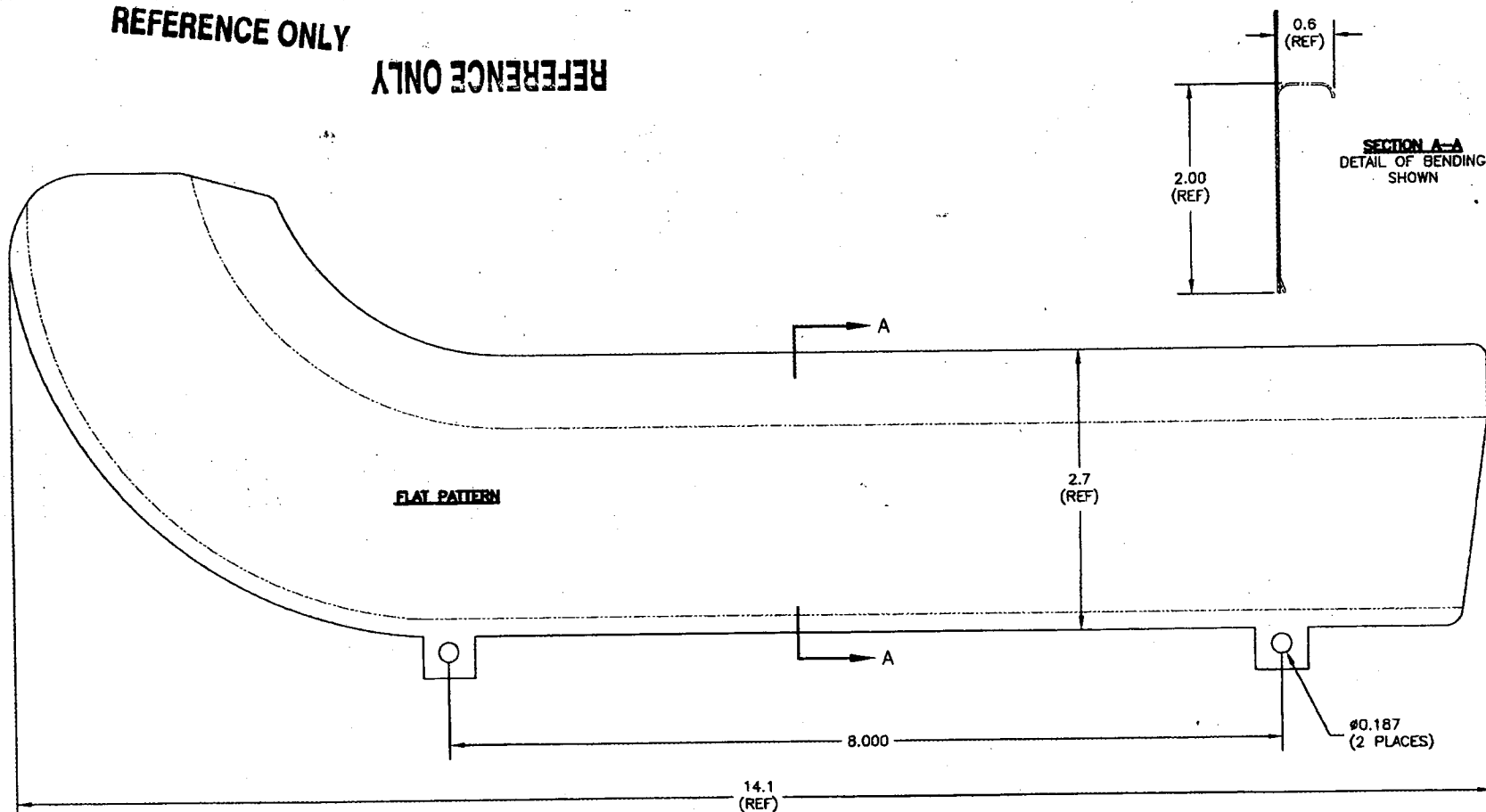
Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.

Raj Thakoordeen

REFERENCE ONLY

REFERENCE ONLY



SECTION A-A
DETAIL OF BENDING
SHOWN

FLAT PATTERN

2.7
(REF)

2.00
(REF)

0.6
(REF)

8.000

14.1
(REF)

Ø0.187
(2 PLACES)

RELEASED

06.09.19

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)

D206-555-002 (BEND OPPOSITE)

- NOTES
- 1) BEND PER M/F TEMPLATE D206-555-T1
 - 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
 - 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAMPSHIRE, ENGLAND, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	REV. C SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES		SCALE 1:1

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
06/10/06

Vendor Address:

T.Q.F. Technologies
6640 Vanden Abeele
St-Laurent, QC H4S 1Y3
Canada
Phone (514) 333-3895
Fax (514) 333-8576

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-TQF001	Oct 04, 2006	N30	Fedex	Oct 18, 2006

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
11.0000	D206555002 B25499	SCUFF PLATE Comments: ELECTRO CHEMICALLY POLISH PER ASTM B912 HIGH SHINE NO SCRATCHES ON SURFACE PLEASE RETURN VIA PUROLATOR COLLECT ACCT: # 7684382	10/18/2006	No	12.600000		138.60
11.0000	D206555001 B27932	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		138.60
10.0000	D206555007 B26228	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		126.00
10.0000	D206555009 B26229	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		126.00

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

REFERENCE ONLY

Comments:

REFERENCE ONLY

Tax Summary:

GST 31.75
GSTME 0.00
GSTND 0.00

Less:

Included tax 0.00
Subtotal 529.20
Total tax 31.75

Entered By: *CL* CLAVOIE

Approved By: *[Signature]*

Total purchase order in

CAD Dollars 560.95

#R 674

Initiator: Jan Keer
Company: Rotor Components (Helicopters)
Phone No. 011 618 9414 1114
Reason for return: Extremely BAD quality.
Customer does

Invoice #
Order Entry #

Date: Nov. 30/07
4683
4202

Attach Copy of DHS Return Authorization # 371

Receiving: 24
Date Received: 8/2/15 Freight Company: Fresh Prepaid ☐ Collect ☐

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-555-001	26008	SCUFF DATE Fwd LH		
1	D206-555-002	25499	" " RH		
1	D206-555-003	31604	SCUFF DATE Aft LH		
1	D206-555-004	30264	" " RH	Done	8/2/15



Condition of packaging: loose Photograph required: yes ☐ no ☒

Paperwork attached: P/S X Invoice ✓ ARC _____ Docs _____ Other _____

QC:

Quarantine: _____ Location: Condition of Part: good

Inspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-555-001	B26008	Return to stock as per W/O's → Scrap & destroy as per W.O.		37671	
1	D206-555-002	B25489			37672	
1	D206-555-003	B31604			37675	
1	D206-555-004	B30264			37676	

QA Coordinator:

Advise GM as to findings: Initial: _____ Date: _____

Comments:

Issue credit: yes no

GM Approval: _____ Date: _____

Invoice Amount: _____
 Less Replacement: _____
 Restock Fee: _____
 Freight: _____
 Net Credit: _____
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit